

Work Order ID 66796

Monday, February 28, 2011 9:30:03 AM



Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH

Start Date: 2/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: C2 Date: 11/02/28 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 003

JB BG 11-6-24

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg D3188,
2- use door to transfer drill hole location.
3- Remove foam core as per IIN- D350-600 figure 17a. Fill holes with Hysol
934NA with 10% milled fiber
A/R Hysol Batch: 117700
EXP: 12-05-13
A/R milled fibers Batch: 100859

25 11-06-21

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

m n ob 23 (1)

133

0.00



SprayPaint

Memo

0.00

Spray Painting

1- Prime as per Qsi 005
A/R primer Batch: 116563
A/R activator batch: 116563

25 11-06-22

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control									
137		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Install hardware to spacepod ensure proper fit								
138	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11 06 23 1

RT 11 06 23 P70-7

11 06 23 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D130-780-042 PAR #: _____ Fault Category: Small Tab NCR: Yes No DQA: 11 Date: 11.07.11
11.10.11 Resolution: Rework Disposition: Rework QA: N/C Closed: OK Date: 11/07/11

NCR: <u>66796</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11-06-23</u>	<u>137</u>	<u>D2237 striker plate installed</u> <u>1/4 too far away</u> <u>R.C. pilot holes for hinges</u> <u>in pad were too close to edge</u> <u>of inner rib</u>	<u>AB</u> <u>OK</u>	<u>remove striker plates</u> <u>repair holes using hysol 934</u> <u>+ milled fibre</u> <u>hysol B# <u>117700</u></u> <u>milled fibre B <u>100859</u></u> <u>drill new holes in proper location</u> <u>touch up as necessary</u>	<u>IT</u> <u>11-06-23</u>	<u>W</u> <u>11-06-23</u>	<u>AB</u> <u>OK</u>	<u>11 06 23</u>
	<u>PC</u>	<u>Per Sam + Dan</u> <u>nature of composite</u> <u>(material properties)</u>		<u>install using new rivets</u> <u>M5.20426 AD4-5x4 B <u>6733</u></u> <u>striker plates D2237 B <u>66139</u></u>				

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Wing Walk as per dwg QSI005 4.4 Batch 117863 0.00

HandFinish

Memo

0.00

Hand Finishing

TOP SURFACE OF POD

IT 11-0623

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BL 11-6-28

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

164/27 U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC4- 100% Inspect kits for completeness	0.00				<i>ml</i>	<i>11</i>	<i>07</i>	<i>05 ①</i>
QC Quality Control	Memo	0.00							
180 	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D130-780-042 Location: _____ PPP Rev: _____	0.00							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Packaging

11/7/16
CMF
11-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 66796

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH



Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:B
10.03.24 revise process and parts DD verified by:EC IPP Rev:C remove D3188-
2m add D3188-6 DD 10.04.07 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2179 Doubler		Manufactured	No			110	Each	42.0000	2	2			
----------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST007 42
35432 42

D3188-6 Spacepod Body		Manufactured	No			110	Each	0.0000	1	1			
------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

MS27039-08-11 Screw		Purchased	No			110	Each	41.0000	2	2			
----------------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST290 41
16280 41

NAS1515H3 Washer		Purchased	No			110	Each	134.0000	2	2			
-------------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location Loc Qty Loc Code

ST277 134
115935 34
116373 100

N/A
Pulled + installed as per
w/o 66798
11.06.23

N/A
Pulled +
installed as per
w/o 66798
11.06.23

B66802

16280
467969

25 11-06-21

22

25 11-06-21

25 11-06-21

22

25 11-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66796

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3815-5
Packer
X1

Manufactured No

160 Each

19.0000

2 3 ✓
JB

Location Loc Qty Loc Code

ST090 11

61318 11

ST091 8

56523 8

61318

MS21059L3
Nut Plate
X1

Purchased No

160 Each

58.0000

10 10 ✓
117881 JB

Location Loc Qty Loc Code

ST301 58

114718 6

116706 52

MS24694-S54
Screw
X1

Purchased No

160 Each

155.0000

6 6 ✓
117460 JB 11/06/24

Location Loc Qty Loc Code

ST289 155

113359 1

116022 54

116900 100

D130-780-044
Spacepod Door Assembly, RH
MS4-1032-130 as per 058-12
Inserts
X1

Manufactured No

110 Each

0.0000

B 66798

1 1
BT 11-06-21

Purchased No

110 Each

0.0000

M 117717

28 28
BT 11-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66796

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3837-4
Decal
installed on w/o 66798
+ pulled
11.06.23

Manufactured No 110 Each 20.0000

Location Loc Qty Loc Code

ST092 20
55570 20

D2237
Striker Plate
11.06.21

Manufactured No 110 Each 81.0000

Location Loc Qty Loc Code

ST009 81
64426 3
64762 14
66139 64

MS20426AD4-5
Rivet
11.06.21

Purchased No 110 Each 5,517.000

Location Loc Qty Loc Code

ST317 5517
6733 535
6874 4982

D3538-1
Hinge Bracket
11.06.21

Manufactured No 110 Each 0.0000

Location Loc Qty Loc Code

ST326 203
16895 203

AN52632R24
Screw
11.06.23

Location Loc Qty Loc Code

ST326 203
16895 203

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66796

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

110

Each

350.0000

WASHER

117316

11-06-23

84

84

11-06-21

Location

Loc Qty

Loc Code

ST297

325

116805

19

116857

306

ST298

25

115996

21

116391

4

11-06-23

32.0000

84

84

11-06-21

MS21042L08

Purchased

No

110

Each

Nut

117677

Location

Loc Qty

Loc Code

ST300

32

116823

32

D3815-041

Manufactured

No

160

Each

22.0000

12

2

JB

Web Assembly

Location

Loc Qty

Loc Code

ST203

22

53469

10

56562

12

56562

1

JB 11/06/24

D3837-1

Manufactured

No

160

Each

13.0000

1

Decal

Location

Loc Qty

Loc Code

ST092

13

46231

1

56382

12

56382

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66796

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Parent Item Name: Spacepod, RH

Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3798-042

Manufactured No

160 Each

1.0000

Spacepod Floor

LocationLoc QtyLoc Code

ST241B

1

53507

1

160 Each

4.0000

D3547-1

Manufactured No

Bracket

LocationLoc QtyLoc Code

ST069

4

57951

4

160 Each

14.0000

D3550-1

Manufactured No

Strut

LocationLoc QtyLoc Code

ST271

14

56332

2

66019

12

160 Each

14.0000

D3554-7

Manufactured No

Ball Stud

LocationLoc QtyLoc Code

ST067

10

65123

10

ST070

4

37674

4

W/O:		WORK ORDER CHANGES					
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Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3015-3

Manufactured No

160 Each

234.0000

Locknut

Location

Loc Qty

Loc Code

ST030

234

60287

9

64275

25

66114

200

Purchased No

160 Each

393.0000

AN3-3A

Bolt

Location

Loc Qty

Loc Code

ST350

393

111193

16

116419

77

116924

300

Purchased No

160 Each

251.0000

AN3-6A

Bolt

Location

Loc Qty

Loc Code

ST351

251

114941

101

116191

50

116704

100

Purchased No

160 Each

80.0000

AN3-10A

Bolt

Location

Loc Qty

Loc Code

ST351

80

116075

2

116400

70

17566

8

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W/O:		WORK ORDER CHANGES					
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Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-5A

Purchased No

160 Each

75.0000



1 1 ✓

Bolt

LocationLoc QtyLoc Code

ST337

75

110865

75

160 Each

487.0000



138 38 ✓

AN525-10R7

Purchased No

Screw

LocationLoc QtyLoc Code

ST325

487

110914

72

113359

15

115016

100

115371

200

116737

100

160 Each

237.0000



17 7 ✓

MS24694-S67

Purchased No

Screw

LocationLoc QtyLoc Code

ST289A

237

106166

21

114341

16

115016

200

160 Each

512.0000



18 8 ✓

AN526C832R14

Purchased No

Screw

LocationLoc QtyLoc Code

ST327

512

104916

512

104916

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS24694-S69

Purchased

No

160

Each

78.0000

1

1

Screw

Location

Loc Qty

Loc Code

ST289A

78

112492

78

110

Each

425.0000

8

8

A3235-020-935

Purchased

No

Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

425

106150

425

160

Each

2,546.000

14

14

NAS1149D0363J

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST298

2546

116583

2546

160

Each

23.0000

16

16

NAS1149D0332J

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST298

23

116441

23

160

Each

750.0000

3

3

NAS1149D0563J

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST298

750

116540

250

116702

500

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Start Date: 2/28/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

160 Each

2,615.000

22 22

Nut

Location

Loc Qty

Loc Code

ST300

2615

114784

9

115835

106

116391

900

116540

800

116549

800

116549

MS21042L5

Purchased No

160 Each

1,006.000

1 1

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

980

115594

284

116105

496

116548

200

116105

AKS4-1032-130

Purchased No

160 Each

0.0000

10 10

Inserts

D130-780-013

Manufactured No

160 Each

2.0000

1 1

Switch Relocation

Location

Loc Qty

Loc Code

FG122

2

53483

1

53905

1

53483

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B

Date: 09.06.11

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: **B**
 Date: 09.06.11